

5/13

SLU 22528 B

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	22528 B
<b>Description:</b> Arm		<b>Part Number:</b>	D3387-042
<b>Dwg:</b> D3387 Rev. A		<b>Qty:</b>	20 <del>40</del>
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.02.23	40
2	MV	Cut blank: 6.000" x 0.500" x 17.800" long Material: 6061-T6/T651 (QQ-A-200/8) (M6061T6B0.500x06.000) <b>Identify for D3387-2</b> Batch: <u>M17029</u> <u>M16791</u>	J.L	05-11-03	40
3	MV	Machine as per Folio FA512 and Dwg D3387 <b>Identify as D3387-2</b>	J.L	05-11-03	40
4	MV	C'sink Ø0.375" as per Dwg D3387	J.L	05/05/31	40
5	QC2	Inspect parts as they come off the CNC machine	J.L	05-11-03	40
6	QC8	Second check	ML	05/03/14	40
7	MV	Tumble and Deburr <b>NO</b> sharp edges	J.L	05-11-03	40
8	QC5	Inspect work to Step 7	J.L	05-11-03	40
9	FP	Chemical Conversion Coat as per QSI 005 4.1	JP	05-05-31	20
10	QC3	Inspect Chemical Conversion Coat	JP	05/06/2	20
11	GA	Press spacer into D3387-2 arm as per Dwg D3387 <b>Pick:</b> Qty Part Number Description Batch 1 D2808 Spacer	2	05-06-02	20
12	QC5	Inspect work to Step 11	HA	05/06/02	20
13	ST	Identify and Stock	HA	05/06/02	20
14	AC	Cost / part: <u>26.17</u>	Sur	05-06-03	20
15	DC	Close W/O <u>26.17</u> Inspect Level 21	HA	05.06.08	20

Rev	Date	Change	Revised By	Approved
A	05.02.22	New Issue	KJ/JLM	HA

RELEASED  
7/15/23



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05.06.02	9-11	Delete step 9, 10, 11 add step 411 to 3388-042 : update BOM		05.06.02	N/A	<i>[Signature]</i>	<i>[Signature]</i> 05.06.02	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

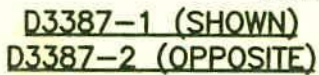
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3387	SHEET 1 OF 1
05.01.18		TITLE	SCALE
		ARM	1:3
A	05.01.18	NEW ISSUE	



- 1) MACHINE PER DRAWING FILE "D3387-A.DWG"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK  
(REF DART SPEC. M6061T6B0.500)
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**Copyright © 2005 by DART AEROSPACE LTD**

Copyright © 2005 by DART AEROSPACE LTD

2000



# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 22, 2005  
03:39 pm

Work Order No : 0022528  
Project Name : D3387-042  
Project For : WK513  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3387-042  
Description : Arm Assembly  
Manufactured : No  
Amount Req'd : *0.40*  
Amount Done : *0*  
Start Date : 02-22-05  
Est Finish Date :  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



DART AEROSPACE LTD		Work Order:	22528
Description: arm		Part Number:	A3387-012
Inspection Dwg: D3387	Rev: A	Page 1 of 1	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	$\pm .010$	.503	✓		vern	
radius .03	<del><math>\pm .03</math></del>	.03	✓			
1.700	$\pm .010$	1.701	✓		vern	
.188	$\pm .010$	.198	✓		vern	
.300 <sup>m</sup>	$\pm .010$	.300	✓		vern	
.507	$\pm .001$	.5065	✓		telescopic	
2.000	$\pm .010$ $\pm .005$	2.002	✓		vern	
1.347	$\pm .010$	1.347	✓		vern	
1.000	$\pm .010$	1.000	✓		vern	
2.033	$\pm .010$	2.029	✓		vern	
-.250	$\pm .010$	-.248	✓		vern	
.125	$\pm .020$ $\pm .0$	.132	✓		mic	
.500	$\pm .010$	.498	✓		vern	
.191	$\pm .010$	.191	✓		vern	
Ø.375	$\pm .010$	.375	✓		vern	

